

Dart Aerospace Ltd.

Date: Tuesday, 22/04/2008 12:36:15 PM  
User: Linda Lacalla

## Process Sheet

Eagle Y6 44255 *File Single*

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL REFERENCE DOOR ASSEMBLY
Job Number	: 37383		
Estimate Number	: 10902		
P.O. Number	:	Part Number	: D412711011
This Issue	: 22/04/2008 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 12/02/2008 Type : PURCHASED PARTS	Drawing Revision	: N/A
Previous Run	: 36802	Material	: N/A
Written By	:	Due Date	: 28/02/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A 04.08.18 New Issue KJ/DS		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D412-711-011 CHG001

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 5687 to Eagle Copters

"Assembly of D412-711-011 Door

Send a copy of this IPP

3.0	D412711041	Vertical Reference Door Assembly
-----	------------	----------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Vertical Ref. Door Assy

4.0	D412711101	Replacement Bubble Window
-----	------------	---------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

5.0	D412711111	Wiring Harness, 212/412
-----	------------	-------------------------



Comment: Qty.: 1.0000 Eagle(s)/Unit Total: 1.0000 Eagle(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-711-111 Wiring Harness, 212/412

Not Required

W/44500Apr 21/08

Date: Tuesday, 22/04/2008 12:36:15 PM  
 User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 37383

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

EA2046915412

Instrument Panel, 412



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 EA20469-15-412 Instrument Panel, 212/412

w/44499

Not Required

Apr 24/08

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door

w/44255

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window

08-001222

1 EA20469-05 Rubber Strip

06-011664

1 EA20469-06 Aluminum Strip

Deleted

1 EA20469-07 Angle

1 EA20469-08 Placard

1 EA20469-10 Rear Rib Assy

1 EA20469-11 Angle

1 EA20469-12 Fwd Rib

1 EA20469-13 Window

1 EA20469-14 Window Retainer

1 EA20469-16 Armrest Assy

1 EA20469-17 Angle

1 EA20469-18 Door Inner Skin

1 EA20469-21 Door Cover Panel

2 EA20469-23 Link

1 EA20469-24 Rod

1 EA20469-25 Arm Assy

w/44499

Material Certification / Proof of Traceability / Certificate of Conformity required

Part Number: D412/11011

Job Number:



Seq. #:

Machine Or Operation:

Description :

## 3-EAGLE

Pick:

Qty	Part Number	Description	Batch
14	AN3-3ABolt		07-018790
22	AN3-4ABolt		08-061209
24	AN3-7ABolt		07-017476
6	AN960-6L Washer		05-022623
90	AN960-10L Washer		06-018522
34	CR3242-4-2 Rivet		08-001645
135	MS20426AD3-3 Rivet		07-006985
140	MS20426AD4-3 Rivet		05-002460
25	MS20470AD3-3 Rivet		07-007189
90	MS20470AD4-3 Rivet		07-015056
24	MS21042L3 Nut		08-002039
2	MS21042L06 Nut		06-014775
13	MS21069L3 Nut Plate		08-001202
8	MS21069L08 Nut Plate		07-018940
1	MS21071L3 Nut Plate		08-002216
1	MS21071L08 Nut Plate		08-001935
9	MS21075L3 Nut Plate		05-004764
2	MS24677-12 Screw		05-011931
6	MS27039-1-09 Screw		07-014232

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



AS

Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

9.0

QC5

INSPECT WORK TO CURRENT STEP



AS

Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Not required - Delivered to A/C AS

Date: Tuesday, 22/04/2008 12:36:15 PM  
User: Linda Lacelle

**Process Sheet**

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 37383

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①  
D 08/04/29

Job Completion



U 08/04/29

# Eagle Copters Maintenance Ltd

## WORK REPORT

Work Order Number: 44401 V/Door

*This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.*

Item: 1 L/H DOOR ASSEMBLY

### Squawk: 1.1

#### Discrepancy:

Modify Door to Vertical Reference Door

#### Resolution:

Modified Door to Vertical Reference Door as per STC No. SH92-55 on Service order P/O 08-000514.1. Door assembled as required.

1.1 Work Done By: John Waite

*The maintenance described above has been performed in accordance with the applicable standards of airworthiness.*

AMO 6-81 Signature: Colin Gould on 3/7/2008

#### Parts:

Part Number	Description	Lot Number	Condition	Qty
204-030-853-037A	SKIN ASSY	LT-07-010860.1	New	1
204-030-499-005	ROLLER ASSY	LT-08-001870	New	1
BELL212-L	BUBBLE WINDOW ILO	LT-08-001222	New	1
	EA20469-03 and			
	D412-711-101			
412-110-103	DOOR HANDLE W/LOCK	LT-07-018126.1	New	1

#### Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
1	204-030-853-125		L/H DOOR ASSEMBLY	Modify

### Squawk: 1.2

#### Discrepancy:

paint door

#### Resolution:

Door painted as required

1.2 Work Done By: Colin Gould

\* End of Report \*

\*\*\*\*\* Original Maintenance Releases and Independent Control Inspection details are stored electronically at \*\*\*\*\*  
\*\*\*\*\* Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software \*\*\*\*\*

# EAGLE COPTERS MAINTENANCE LTD.

823 McTAVISH ROAD N.E. CALGARY ALBERTA T2E 7G9

DOC APPROVAL NO. 6-81

Nomenclature

Door Cop 107

Manufacturer

BHT

Type/Model

Part No. 2047030-853-125

Serial No.

W/K

Total time

W/K

Work Order

74401

ISO

W/K

Overhaul

NEW

Inspected

☒

Tested

☒

Repair

☒

Modification

☒

Removal

☒

Previous Certification

C6FWT

The maintenance described has been performed in accordance with the applicable standards of airworthiness.

12-06-68

DATE

NAME OR AUTHORIZED INSPECTOR

LIC. NO. / STAMP

Details of outstanding work and other information (if any)

Eagle 37

0412-711-041  
0/37383

MAINTENANCE RELEASE

REMARKS

(Details of work performed / reason for removal)  
Modified as per STC 8497-53


(Additional work to be performed upon installation)

INSTALLED ON

DATE

Date: Tuesday, 22/04/2008 12:36:20 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: VERTICAL REFERENCE DOOR ASSEMBLY
<b>Job Number</b>	: 37384		
<b>Estimate Number</b>	: 10902		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D412711011
<b>This Issue</b>	: 22/04/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: N/A
<b>First Issue</b>	: 12/02/2008	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 37383	<b>Drawing Revision</b>	: N/A
	<b>Type</b> : PURCHASED PARTS	<b>Material</b>	: N/A
<b>Written By</b>	: 	<b>Due Date</b>	: 28/02/2008
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	1
<b>Comment</b>	: Est Rev:A 04.08.18 New Issue KJ/DS	<b>Um:</b>	Each

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D412-711-011 CHG001

2.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 5687 to Eagle Copters

"Assembly of D412-711-011 Door

Send a copy of this IPP

c 208/02/12①

3.0

D412711041

Vertical Reference Door Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Vertical Ref. Door Assy

4.0

D412711011

Replacement Bubble Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

5.0

D412711111

Wiring Harness, 212/412



Comment: Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-711-111 Wiring Harness, 212/412

Date: Tuesday, 22/04/2008 12:36:20 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 37384

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

EA2046915412

Instrument Panel, 412



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 EA20469-15-412 Instrument Panel, 212/412

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window

1 EA20469-05 Rubber Strip

1 EA20469-06 Aluminum Strip

1 EA20469-07 Angle

1 EA20469-08 Placard

1 EA20469-10 Rear Rib Assy

1 EA20469-11 Angle

1 EA20469-12 Fwd Rib

1 EA20469-13 Window

1 EA20469-14 Window Retainer

1 EA20469-16 Armrest Assy

1 EA20469-17 Angle

1 EA20469-18 Door Inner Skin

1 EA20469-21 Door Cover Panel

2 EA20469-23 Link

1 EA20469-24 Rod

1 EA20469-25 Arm Assy

Material Certification / Proof of Traceability / Certificate of Conformity required



Date: Tuesday, 22/04/2008 12:36:20 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 37384

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-EAGLE

Pick:

Qty Part Number Description Batch

14 AN3-3ABolt \_\_\_\_\_

22 AN3-4ABolt \_\_\_\_\_

24 AN3-7ABolt \_\_\_\_\_

6 AN960-6L Washer \_\_\_\_\_

90 AN960-10L Washer \_\_\_\_\_

34 CR3242-4-2 Rivet \_\_\_\_\_

135MS20426AD3-3 Rivet \_\_\_\_\_

140MS20426AD4-3 Rivet \_\_\_\_\_

25 MS20470AD3-3 Rivet \_\_\_\_\_

90 MS20470AD4-3 Rivet \_\_\_\_\_

24 MS21042L3 Nut \_\_\_\_\_

2 MS21042L06 Nut \_\_\_\_\_

13 MS21069L3 Nut Plate \_\_\_\_\_

8 MS21069L08 Nut Plate \_\_\_\_\_

1 MS21071L3 Nut Plate \_\_\_\_\_

1 MS21071L08 Nut Plate \_\_\_\_\_

9 MS21075L3 Nut Plate \_\_\_\_\_

2 MS24677-12 Screw \_\_\_\_\_

6 MS27039-1-09 Screw \_\_\_\_\_

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Date: Tuesday, 22/04/2008 12:36:20 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 37384

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

